

Work Order ID 155409

Friday, January 13, 2017 10:33:53 AM

155409

Page 1

Item ID: D2804-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket Assembly
 Start Date: 1/13/2017 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 1/27/2017 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: mf Date: 17-1-13 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2804	D

100 0.00
100 Small Fab 2x 17/02/01 DAS 36 9-89
 Small Fab Memo 0.02
 Small Fab Press D2805-1 and D2809 Into arm as per Dwg D2804

110 0.00
110 QC5- Inspect part completeness to step on W/O 2 FEB 02 2017 DAS 36 9-89
 QC Memo 0.01
 Quality Control

120 0.00
120 Grey Sandtex(Ref: 4.3.5.6) per QSI005 4.3 2 17-02-7 333
 Powdercoat Memo 0.00
 Powder Coating START TIME: 8:10 OVEN TEMPERATURE:
 FINISH TIME: 8:40

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location <u>GA</u>	0.00							
170									
Packaging	Memo <u>w/o</u>	0.00				<u>2x</u>			<u>17/2/18</u>
Packaging	<u>155219</u>								
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.03							<u>17/2/19</u>
Quality Control									

DAS
21
9-89

FEB 08 2017

DQA: _____ Date: _____



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Picklist Print

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Page 1

Work Order ID: 155409

155409

Parent Item: D2804-041

D2804-041

Parent Item Name: Bracket Assembly

Start Date: 1/13/2017

Required Date: 1/27/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP F05.03.30MS21043-3 was MS21042L3KJ/JLM
IPP Rev:G As per Rev C 06-11-08 JLM
IPP REV:H 16.06.23 AS PER DWG REV.D DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2804-1 *D2804-1* Bracket		Manufactured	No			100	Each	2.0000	1	2			
									**			17/02/01	DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST474				2					
				146608				2					
D2805-1 *D2805-1* Stop		Manufactured	No			100	Each	11.0000	1	2			
									**			17/02/01	DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				11					
				149393				11					
D2809 *D2809* Washer		Manufactured	No			100	Each	29.0000	1	2			
									**			17/02/07	DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				4					
				130466				1					
				146514				2					
				149434				1					
				ST011				25					
				138750				14					
				34035				11					

B156588
2x

DQA: _____ Date: _____



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Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Picklist Print

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Page 2

Work Order ID: 155409

155409

Parent Item: D2804-041

D2804-041

Parent Item Name: Bracket Assembly

Start Date: 1/13/2017

Required Date: 1/27/2017

Start Qty: 2.00

Required Qty: 2.00

AN3C16A Purchased No

150 Each 29.0000 2 4

AN3C16A

BOLT

**

17/02/07 DAS 36 9-89

Location

Loc Qty

Loc Code

ST348

29

m135704

29

4

D3672-15 Manufactured No

150 Each 271.0000 4 8

D3672-15

Phenolic Washer

**

17/02/07 DAS 36 9-89

Location

Loc Qty

Loc Code

ST049

21

149430

21

8

ST051A

250

151784

250

MS21043-3 Purchased No

150 Each 1,152.000 2 4

MS21043-3

Nut

**

17/02/07 DAS 36 9-89

Location

Loc Qty

Loc Code

FG

80

103691

80

FP001

403

m130673

11

m136182

392

GA

415

m133990

27

m136295

388

4

ST302

185

m135864

185

ST304

69

m131340

69

Friday, January 13, 2017 10:33:53 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____

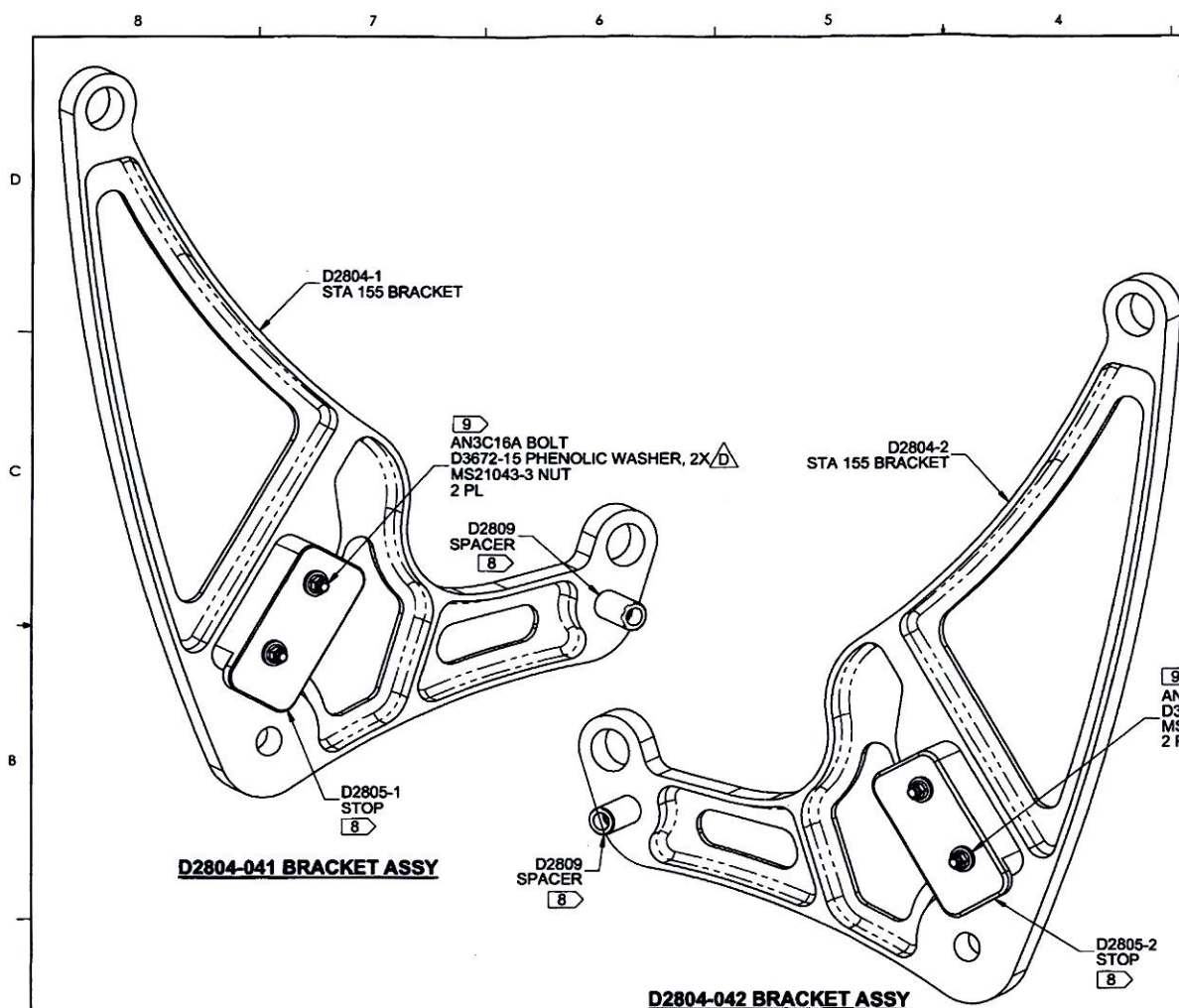


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OTHER : _____					



ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
	X		D2804-041	BRACKET ASSY
		X	D2804-042	BRACKET ASSY
1	1		D2804-1	STA 155 BRACKET
2		1	D2804-2	STA 155 BRACKET
3	1		D2805-1	STOP
4		1	D2805-2	STOP
5	1	1	D2809	SPACER
6	4	4	D3672-15	PHENOLIC WASHER
7	2	2	AN3C16A	BOLT
8	2	2	MS21043-3	NUT, SELF-LOCKING

71F
155409

RELEASED

2016 JUN 22
ECN 16-661

D	REVISE TO CURRENT FORMAT: D3672-15 WAS NAS1515H3; MS21043-3 WAS MS21042-3; ADD CSINK (SECTIONS E-E AND J-J). REF: PAR16-699. D6-3/4: 2.656 WAS 2.654 REASON: CAD ERROR.	MB	16.04.11
C	CHANGE GEOMETRY TO ADD CLEARANCE	CP	06.10.16
B	ADD CUTOUTS AND -.043/-044	CP	04.11.22
A	NEW ISSUE	CP	00.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	MB		
CHECKED	ML	DRAWING NO.	REV. D
MFG. APPR.	JLM	D2804	SHEET 1 OF 4
APPROVED	WM	TITLE	SCALE
DE APPR.	DS-#	STA 155 BRACKET	NTS
DATE	16.04.11	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT "GLOSS WHITE" (4.3.5.1) OR "GREY SANDEXT" (4.3.5.6) OR "BLACK SANDEXT" (4.3.5.7) OR "GREEN SANDEXT" (4.3.5.8) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
 - 7) WEIGHT: 1.37 lbs
 - 8) PRESS D2805-X AND D2809 INTO PLACE PRIOR TO POWDER COAT
 - 9) INSTALL BOLT WITH LPS-3 CORROSION INHIBITOR, ENSURE NO LPS-3 ON THREADS

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